

Split 2 06.08.03

Date: Tuesday, 5/23/2006 8:13:06 AM  
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 27169 - 2-2	
Estimate Number : 10313	
P.O. Number : N/A	Part Number : D26483
This Issue : 5/23/2006 S.O. No. : N/A	Drawing Number : D2648 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : D
Previous Run : 25904	Material : N/A
Written By : <u>SKK</u> COMMENT: BELOW	Due Date : 6/5/2006 Qty: 400 Um: Each
Checked & Approved By : <u>06.05.23</u>	
Comment : Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 1312  
Email or ship DXF file to vendor  
Make per Drawing D2648-1  
Material release note required

CY06105124

400

2.0 D26483F Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 400.0000 Each(s)  
WEARPAD

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage  
Ensure material release note is attached

AR 06/06/01 402

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06.06.01 402

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr if necessary

N/A SA 06/06/01 402



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## Process Sheet

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Drawing Name: WEARPAD

Job Number: 27169

Part Number: D26483

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D2648-3

SAD

06:06:02

402

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R560Hardcoat

M100942

M101217

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

H.M 06/06/13

402

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AA 06/06/13

402

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AA 06/06/13

402

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

DL 06/08/02

182

P10

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AB 06/08/02

182

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ~~EP~~ 15

DL 06/08/02

182

13.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/08/02

182

W 06/08/02

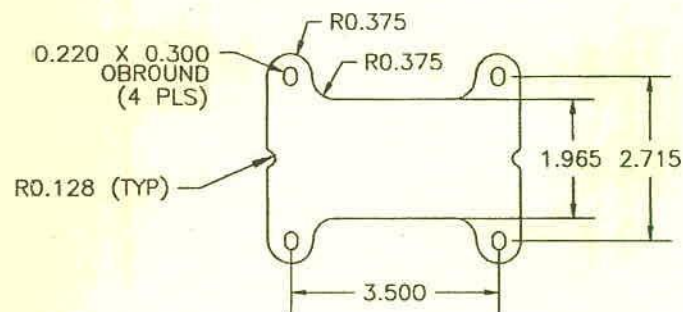
oculosloz

10.0

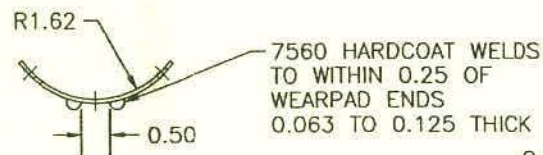
split w/o. need aty of 182 on split-2

aty remaining 220 on ~~this~~ original

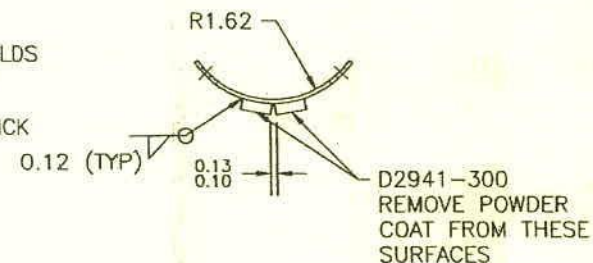
# D2648-1 FLAT PATTERN



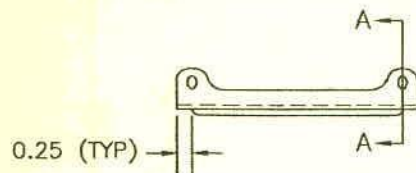
## SECTION A-A



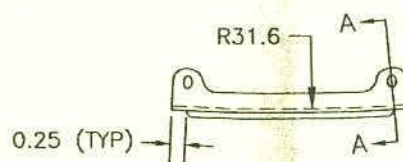
## SECTION B-B



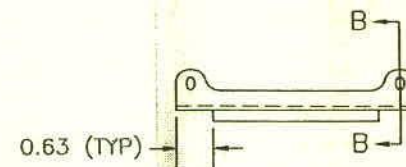
## D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



## D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



## D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)



RELEASED  
9.12.20 DS



BREAK ALL SHARP CORNERS 0.063 MAX  
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)  
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

NO. 27169  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBOUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2648
DATE		TITLE WEARPAD
99.11.17		REV. D SHEET 1 OF 1 SCALE 1:2





California Steel Industries  
14000 San Bernardino Ave.  
Fontana, California 92335  
PH (909) 350-6300

# CERTIFIED TEST REPORT

CUSTOMER ORDER P50614ME002	MO. NUMBER 02-8344-01	SHIPPING DATE 08/01/05	CAR NUMBER RR: WCTR142061	TALLY NUMBER PO 250499136 1/
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B I L L T O	WILKINSON STEEL AND METALS A DIVISION OF PREMETAL CO., INC. 888 S.E. MARINE DR., VANCOUVER BC, CANADA, V5X2V3	S H I P T O	WILKINSON STEEL-METALS C/O GARY R. HAMILTON TRUCKING 888 S.E. MARINE DR., VANCOUVER BC, CANADA BC V5Y 2
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MARK ALL DOCUMENTS W/P.O. P50614ME002. FAX TALLIES AT TIME OF SHIPMENT TO MEL ELIAS FAX #604-301-3244.

END USE WAREHOUSE STOCK - NON-CRITICAL SURFACE

PROD H.R. COILS - P & C - PRIME

SPEC ASTM-A-1011-00-CS-TYPE B

T/R INSPECTION MILL

DESCRIPTION	COILS, PIECES OR BUNDLES	HEAT NUMBER	
.0605 x 48.0000 x COIL NOM ME	1	T42354	
	1	T42348	

I CERTIFY THE FOLLOWING TEST INFORMATION TO BE CORRECT AS CONTAINED IN THE RECORDS OF THE COMPANY.

*Ante B. Jenkins*

CHIEF - LABORATORY SERVICES

MECHANICAL PROPERTIES							CHEMICAL ANALYSIS															10:48:05		08/01/05		CO
HEAT OR LOT NUMBER	SLAB NUMBER	LOC	YIELD KSI	TENSILE STRENGTH KSI	% ELONGATION		BEND TEST	C	Mn	P	S	Si	Cu	Ni	Cr	Mo	Al	V	Co	Ti	N					
					1"	2"																				
T42354								08	.38	010	006	006	01	01	01	00	050	000	000	000	002					
T42348								08	.38	014	010	007	01	01	01	00	046	000	000	001	003					
CTR-001 PTLUC32L 990712																										

CTR-001 PTLUC22L 990712



New Zealand Steel Limited  
Christchurch, South Island  
Postal: Private Bag 9272, Auckland New Zealand  
Telephone: (09) 278 8999 / 373 8111  
Fax: (09) 275 8999

# TEST CERTIFICATE

WMS 5412057C1

CUSTOMER	WILLMORRIS	151123amcc03
CUSTOMER ON	98-31N-108	
MILL ON	518691	
SPECIFICATION	ASTM A1011 CS Type B	
PRODUCT	HOT ROLLED PICKLED & OILED	
DIMENSIONS	0.104" ± 45" x 48"	
DATE	17 January 2006	
PAGE	1 of 1	
CERTIFICATE NO	TC124648	

PACK NUMBER	TREAT NO	CHEMICAL COMPOSITION PERCENT													MECHANICAL TESTS (TEST SPECIFICATION)			
		C	SI	Mn	P	S	CU	NI	CL	MO	V	NB	TI	AL	B	N2	CEI	BEND
HP-997711-00	64664	6	1	20	9	19												Good
HP-997712-00	64664	6	1	20	9	19												Good
HP-997713-00	64664	6	1	20	9	19												Good
HP-997714-00	64664	6	1	20	9	19												Good
HP-997715-00	64664	6	1	20	9	19												Good
HP-997716-00	64664	6	1	20	9	19												Good
HP-997717-00	64664	6	1	20	9	19												Good
HP-997718-00	64664	6	1	20	9	19												Good
HP-997719-00	64664	6	1	20	9	19												Good
HP-997720-00	64664	6	1	20	9	19												Good
HP-997721-00	64664	6	1	20	9	19												Good
HP-997722-00	64664	6	1	20	9	19												Good

YIELD	GAUGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (I)	IMPACT TEST	CARBON EQUIVALENT VALUE (CEI)	OTHER
(A)-2% PROOF STRESS	(A)-20mm (C)-80mm	(A)-145 (C)-145	(A)-10mm x 10mm (E)-2.5mm x 10mm	(A)-C-Mn (B)-C-Mn (C)-C-Mn (D)-C-Mn (E)-C-Mn (F)-C-Mn (G)-C-Mn (H)-C-Mn (I)-C-Mn (J)-C-Mn (K)-C-Mn (L)-C-Mn (M)-C-Mn (N)-C-Mn (O)-C-Mn (P)-C-Mn (Q)-C-Mn (R)-C-Mn (S)-C-Mn (T)-C-Mn (U)-C-Mn (V)-C-Mn (W)-C-Mn (X)-C-Mn (Y)-C-Mn (Z)-C-Mn	
(B)-LOWER YIELD STRESS	(B)-50mm (D)-5.65 x 50	(B)-150 (D)-150	(B)-10mm x 10mm (F)-2.5mm x 10mm		

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION.

APPROVED

Anthony Mistry

QUALITY CONTROL

